



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3167-1

Job Sheet 181643



Part No: D3167-1

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Waterjet		DC 18/08/03
120	Waterjet	4 pcs	8/10/18	8/10/18	0.00	1.36	Waterjet1		DC 18/08/03
130	CNC Vertical Machining	4 pcs	8/10/18	8/10/18	0.66	6.56	HAAS1-3		DSP 18-08-21
140	QC	4 pcs	8/10/18	8/10/18	0.00	0.00	QC2 Machining-1		DSP 18-08-21
150	QC	4 pcs	8/10/18	8/10/18	0.00	0.00	QC8 Machining-1		21 AUG 18/08/22
151	Packaging	4 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3		AUG 23 2018
190	QC21-SA	4 Ea	8/10/18	8/10/18	0.00	0.00	QC21		

Part Op 120 - Cut Blank as per File D3167-1_BLANK

Descriptions: 130 - Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA285 and Dwg D3167

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	14.4000 sf (3.6 ea)	90-Start up Operation	5045595 5045596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	14	1,117	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.060inches + 0.030 - 0.010	0.090 0.050	0.060	
2	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
3	Bearpaw	5.800inches ± 0.030	5.830 5.770	5.792	
4	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	
5	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
6	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	Radius

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																						
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																				
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																				
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																				
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Date : _____		Step # : _____		QTY Effective : _____		MRB (QSI042) Approval																																																				
Description				Disposition																																																						
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-8200 Email: sales@dartaero.com www.dartaerospace.com Container No: S099280 Part: D3167-1 Job No: 181643 Serial No/Batch: S099280 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 08/03/18				Completed By																																																						
				Lead hand / Supervisor Approval Verification																																																						
				QC / QA Coordinator Approval																																																						
<table border="1"><thead><tr><th colspan="2">Root Cause</th><th colspan="2">FAULT CATEGORY</th></tr></thead><tbody><tr><td>Environment ☐</td><td>No Re-v ☐</td><td>Crushing ☐</td><td>Positioned Wrong ☐</td></tr><tr><td>Design ☐</td><td>Operato ☐</td><td>Heat Treat ☐</td><td>Outside Dimensions ☐</td></tr><tr><td>Doc/Data ☐</td><td>Offset/☐</td><td>Wave/Twist in Tube ☐</td><td>Over/Under tolerance ☐</td></tr><tr><td>Equip/Tooling ☐</td><td>Supplie ☐</td><td>Marks/Chatter ☐</td><td>Part Incorrect ☐</td></tr><tr><td>Handling/Pre ☐</td><td>Trainin ☐</td><td></td><td>Part Lost/Missing ☐</td></tr><tr><td>Material ☐</td><td>Use for Testing ☐</td><td></td><td>Part Moved ☐</td></tr><tr><td>Internal Transport ☐</td><td>Poor Information ☐</td><td>Cut Too Short ☐</td><td>Drawing ☐</td></tr><tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td><td>Instructions Incomplete/Unclear ☐</td><td>Finish ☐</td></tr><tr><td>LOA ☐</td><td>Product Improvement ☐</td><td>Drill Holes ☐</td><td>Misread ☐</td></tr><tr><td>Substation ☐</td><td>Process Improvement ☐</td><td></td><td>Turning Sequence ☐</td></tr><tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td><td></td><td></td></tr><tr><td>Misidentified ☐</td><td>Past Due ☐</td><td>OTHER : _____</td><td></td></tr></tbody></table>							Root Cause		FAULT CATEGORY		Environment ☐	No Re-v ☐	Crushing ☐	Positioned Wrong ☐	Design ☐	Operato ☐	Heat Treat ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/ ☐	Wave/Twist in Tube ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplie ☐	Marks/Chatter ☐	Part Incorrect ☐	Handling/Pre ☐	Trainin ☐		Part Lost/Missing ☐	Material ☐	Use for Testing ☐		Part Moved ☐	Internal Transport ☐	Poor Information ☐	Cut Too Short ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Instructions Incomplete/Unclear ☐	Finish ☐	LOA ☐	Product Improvement ☐	Drill Holes ☐	Misread ☐	Substation ☐	Process Improvement ☐		Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER : _____	
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7	Bearpaw	0.200inches $\pm$ 0.030	0.230 0.170	0.1925	
8	Bearpaw	0.250inches $\pm$ 0.010	0.260 0.240	0.245	
9	Bearpaw	0.625inches $\pm$ 0.030	0.655 0.595	0.627	
10	Bearpaw	0.375inches $\pm$ 0.010	0.385 0.365	0.378	
11	Bearpaw	0.950inches $\pm$ 0.030 - 0.010	0.980 0.940	0.955	
12	Bearpaw	3.210inches $\pm$ 0.030	3.240 3.180	3.205	
13	Bearpaw	19.000inches $\pm$ 0.030	19.030 18.970	19.00	
14	Bearpaw	0.260inches $\pm$ 0.005	0.265 0.255	0.260	Diameter
15	Bearpaw	0.930inches $\pm$ 0.030	0.960 0.900	0.932	Diameter
16	Bearpaw	0.300inches $\pm$ 0.030 - 0.000	0.330 0.300	0.320	
17	Bearpaw	0.375inches $\pm$ 0.030	0.405 0.345	0.378	
18	Bearpaw	7.230inches $\pm$ 0.030	7.260 7.200	7.230	
19	Bearpaw	4.540inches $\pm$ 0.010	4.550 4.530	4.540	
20	Bearpaw	2.000inches $\pm$ 0.030	2.030 1.970	2.000	
21	Bearpaw	12.000inches $\pm$ 0.010	12.010 11.990	12.000	
22	Bearpaw	6.000inches $\pm$ 0.010	6.010 5.990	6.000	
23	Bearpaw	23.750inches $\pm$ 0.030	23.780 23.720	23.750	

DIP 18-08-21

Plex 8/2/18 2:44 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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